

# Work Order ID 116773

June-10-14 9:48:32 AM

**\*116773\***

Page 1

Item ID: 646.9603

646.9603

Revision ID:

**B-116773**

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Item Name: Lower Cutter Assy Low

Stop **\*NS2\***

Start Date: 4/23/14 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 4-26-10

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
646.9600	N/C

110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									

120		0.00							
<b>*120*</b>									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								

A/R RTV LOCTITE 598: 127443  
exp. date: 10/15

130	QC5- Inspect part completeness to step on W/O	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
27  
9-89  
M/G/12

5 0 0 AS 14-6-11

5 0 0 AS 14-6-11

S

Work Order ID 116773

\*116773\*

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Item ID: 646.9603 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Lower Cutter Assy Low  
 Start Date: 4/23/14 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 4/23/14 Req'd Qty: 5.00 \*5\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>SI</u>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

5X DAS 28 9-89 JUN 12 2014  
ML5 1406-12  
ML5 1406-12

# Picklist Print

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Work Order ID: 116773

**\*116773\***

Parent Item: 646.9603

**\*646 9603\***

Parent Item Name: Lower Cutter Assy Low

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No			110	Each	16.0000	1	5			

**\*646 9701\***

Cutter Sub Assembly

**\*\***

*AS 14-6-11*

Location	Loc Qty	Loc Code
CA	9	
113350	4	
91788	5	
MF	3	
109590	3	
ST	4	
110325	4	

2
3

646.9813

Manufactured No

110

Each

12.0000

1

5

**\*646 9813\***

Lower Deflector Low

**\*\***

*AS 14-6-11*

Location	Loc Qty	Loc Code
CA	12	
89844	6	
m126249	6	

5
---

# Picklist Print

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Work Order ID: 116773

**\*116773\***

Parent Item: 646.9603

**\*646 9603\***

Parent Item Name: Lower Cutter Assy Low

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

110

Each

5,144.000

3

15

**\*MS21042L 08\***

**\*\***

*AS 14-6-11*

Nut

Location

Loc Qty

Loc Code

ST314

3211

123900

58

m128401

1500

m128429

1653

ST508

1834

125443

436

m127410

1398

ST509

99

m127304

99

MS27039-08-19

Purchased

No

110

Each

2,050.000

3

15

**\*MS27039-08-19\***

**\*\***

*AS 14-6-11*

Screw

Location

Loc Qty

Loc Code

ST506

2050

124309

648

125654

127

m127410

275

m127904

1000

NAS1149FN832P

Purchased

No

110

Each

9,564.000

6

30

**\*NAS1149FN832P\***

**\*\***

*AS 14-6-11*

Washer

Location

Loc Qty

Loc Code

ST295

430

123185

30

123522

400

st510

9134

125268

9134

30

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Shop Packet Print

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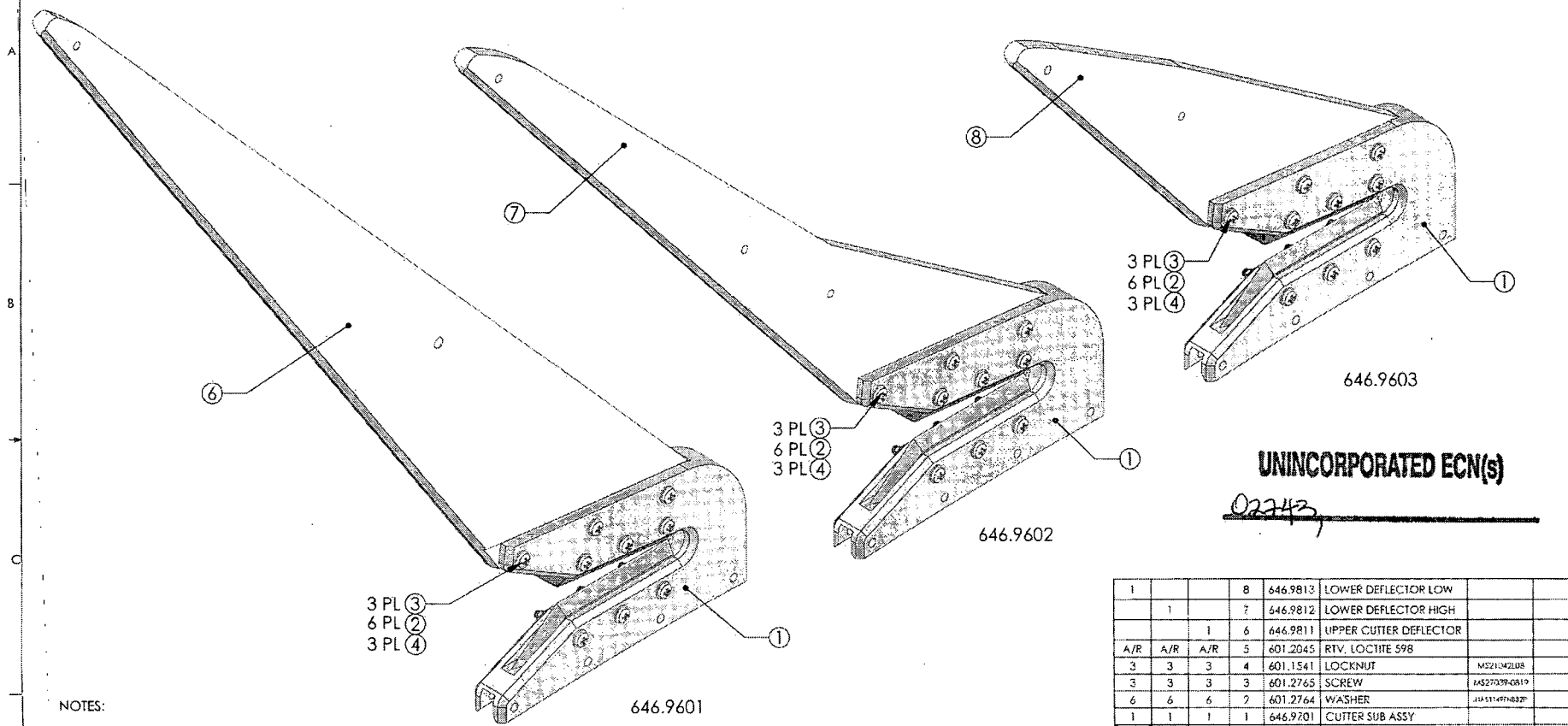
<b>APICAL</b> INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743			SHEET 1 OF 1	
	DWG NO. 646.9600	REV IN/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: CUTTER ASSY				
APPROVED BY: ENGR <i>P. Brans</i>		MFG <i>Samuel Jones</i>	QC <i>Wanda Lopez</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED SCREW LENGTH.			

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 116773 MJS  
 1406-10

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM							CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
DER REVIEW REQUIRED							<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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REV.	DESCRIPTION	DATE	APPROVED
LAST PROTOTYPE REVISED PER			ENC
ENC	INITIAL RELEASE	04/25/00	P. DRAYNO



646.9603

UNINCORPORATED ECN(s)

02243

646.9602

646.9601

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

1			8	646.9813	LOWER DEFLECTOR LOW		
	1		7	646.9812	LOWER DEFLECTOR HIGH		
		1	6	646.9811	UPPER CUTTER DEFLECTOR		
A/R	A/R	A/R	5	601.2045	RTV, LOCITE 598		
3	3	3	4	601.1541	LOCKNUT	MS21342L08	
3	3	3	3	601.2765	SCREW	MS27039-0819	
6	6	6	2	601.2764	WASHER	J1411149F0832P	
1	1	1	1	646.9701	CUTTER SUB ASSY		
				646.9603	LOWER CUTTER ASSY LOW		
				646.9602	LOWER CUTTER ASSY HIGH		
				646.9601	UPPER CUTTER ASSY		
.9603	.9602	.9601	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES			
646.9500				2608 TEMPLE HEIGHTS DR.			
				OCEANSIDE, CA. 92056-3512 (760)724-5300			
				CUTTER ASSY			
				SEE CASE CODE 07M26			
				646.9600			
				SCALE NONE			
				SHEET 1 OF 1			